



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D135-1027-243
Job Sheet 190542



Part No: D135-1027-243

Job Qty: 1 pcs

Part Name: MID HEIGHT AFT Crosstube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No:

Due Date: 3/22/19

Created By: Jesse White

Type: SOLD

Description:

Note: D135-1027-243 REV.C IPP REV:A 17.09.08 NEW ISSUE DD VERF:DP IPP REV:B 17.10.24 AS PER DWG
REV.B DD VERF:DP IPP REV:C 18.11.08 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Chgo
see attachment

Bill of Materials

DAG
21
9-89

Route updated

DAS
35
9-89

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Crosstubes - 1	1 pcs		3/22/19	0.00	0.25	Crosstubes - 1			
							Crosstubes - 2			
							Crosstubes - 3			
							Crosstubes - 4			
110	QC 7	1 pcs		3/22/19	0.00	0.00	QC 7 - 10			AS 19-7-23
							QC 7 - 13			
							QC 7 - 14			
							QC 7 - 15			
							QC 7 - 17			
							QC 7 - 18			
							QC 7 - 19			
							QC 7 - 2			
							QC 7 - 28			
							QC 7 - 3			
							QC 7 - 30			
							QC 7 - 34			
							QC 7 - 36			
							QC 7 - 37			
							QC 7 - 41			
							QC 7 - 47			
							QC 7 - 48			
							QC 7 - 51			
							QC 7 - 58			
							QC 7 - 59			
							QC 7 - 6			
							QC 7 - 60			
							QC 7 - 9			
							QC 7 - 68			
							QC 7 - 50			
							QC 7 - 67			

AS 19-7-27



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S199717



Part: D135 - 1027 - 243

Job No: 190542

Serial No/Batch: S199717

Revision: C

Inspector:

Exp Date:

Instructions: TC STC SH18-49 Issue 1, FAA STC SR04276NY dated 18/11/21, E

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

120 Handfinish - 4-1-Assembly-B4B	1 pcs	3/22/19	0.00 0.25	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	• AB 19-7-28
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
140 Spray Paint - 2 - B4B	1 pcs	3/22/19	0.00 1.00	Spray Paint - 1 - B4B	• AB 19-8-2
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
150 QC 14	1 pcs	3/22/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
155 Handfinish - 4-2-Assembly-B4B	1 pcs	3/22/19	0.00 0.67	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	• RD 19-8-8
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
160 QC 7	1 pcs	3/22/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	

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NCR No.

Route update only

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				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
170	Packaging 3-1 - Stock - B4B	1 pcs	3/22/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
180	QC 21 - SA	1 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

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Part Op 100 - (Chemical Conversion Coat per QSI005 4.1), ***PRIOR TO CHEMICAL CONVERSION*** SCRIBE DART P/N AND

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Descriptions: B/N ON INSIDE OF CUFF PER QSI 044 6.4

110 - (QC7-Inspect Chemical Conversion Coat)

120 - (Assemble as per dwg), INSTALL THREADED ROD AS PER DWG AND APPLY LOCKTITE 263 (NOTE 9) AND SEAL BETWEEN THE NUT AND CROSSTUBE USING SEALANT(NOTE10)

140 - (Spray Paint / NDT Room), ***MASK PRIOR TO PRIME AND PAINT AS PER NOTE11, BOTH ENDS*** 1- PRIME INSIDE AND OUTSIDE PER QSI005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: 5189559 2- PAINT OUTSIDE SURFACE AS PER QSI005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: 5198581 3- COAT INSIDE SURFACE WITH LPS PROCYON AS PER DWG, QSI005 4.8 4- AFTER FINISH APPLY A 1 INCH CENTER LINE ON TOP OF CROSSTUBE WITHIN 0.1" OF CENTERLINE QSI 044 6.1(SEE NOTE 12 AND 13)

150 - (QC14- Inspect Spray Paint)

155 - ***CROSSTUBE*** ASSEMBLE AS PER DWG NOTE 13. USE SOAP AND WATER IF NECESSARY AS PER DWG NOTE 14. TORQUE BOLT TO 50-70 IN-LBS AS PER NOTE 13.

160 - QC7-Inspect Chemical Conversion Coat

170 - (Identify as per dwg & Stock Location:_____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D135-1027-253	Mid Height Aft Crosstube	1 pcs (1 ea)	100-Crosstubes - 1	<u>5164506</u>
D5511-1	Threaded Rod	3 pcs (3 ea)	100-Crosstubes - 1	<u>5192214</u>
MS35650-304	Nut	6 Ea (6 ea)	100-Crosstubes - 1	<u>5155670</u>
NAS1149D0363J	Washer	6 Ea (6 ea)	100-Crosstubes - 1	<u>5176545</u>
D5411-1	Rubber Bushing	2 pcs (2 ea)	155-Handfinish - 4-2-Assembly-B4B	<u>5151241</u>
D5412-041	Crosstube Clamp Assembly	2 pcs (2 ea)	155-Handfinish - 4-2-Assembly-B4B	<u>5167693</u>
D5413-1	Crosstube Support	2 pcs (2 ea)	155-Handfinish - 4-2-Assembly-B4B	<u>5163846</u>
D5414-1	Support Bolt	4 pcs (4 ea)	155-Handfinish - 4-2-Assembly-B4B	<u>5158859</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Crosstubes - 1	D135-1027-253	1	0	0
	D5511-1	3	17	0
	MS35650-304	6	20	0
	NAS1149D0363J	6	796	0
	D5411-1	2	30	0
155-Handfinish - 4-2-Assembly-B4B	D5412-041	2	16	0
	D5413-1	2	16	0
	D5414-1	4	38	0

Part Specifications

Specifications could not be found.

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong
		☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance
		☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing
		☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish
		☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing
		☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread
		☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
Other/Details:					

Change Record

PAGE 1 OF 1

Part Number: D135-1027-243

Description: MID HEIGHT AFT CROSSTUBE ASSEMBLY

[illegible]